

Split

Date: Wednesday, 1/30/2008 7:56:56 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT PIN BRACKET  
Job Number : 37079 -1  
Estimate Number : 11207  
P.O. Number :  
This Issue : 1/30/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D333013  
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D3330 REV D  
Previous Run : Project Number : N/A  
Written By : Material :  
Checked & Approved By : Due Date : 2/18/2008 Qty: 10 Um: Each  
Comment : Est. A 05.01.13 New issue KJ/JLM  
est b 07.05.14 rev c dwg ec  
Est C 07.12.12 Rev D dwg EC verified by:DD

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 M1010B2500X01000 1010-1025 Steel Bar



Comment: Qty: 0.4485 f(s)/Unit Total: 8.9691 f(s)

1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel  
(M1010-B2.500x01.000)

Identify for D3330-13

Batch: M102220

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 2.500" x 1.000" x 3.00" long (+/-0.030)

85 08/02/25

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA480 and Dwg D3330

Identify as D3330-13

Deburr

DSP/ 85 08/02/25

PTC ->

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 08/02/26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3330-013 PAR #: N/A Fault Category: Prod / Machines / Jt NCR: Yes No DQA: D Date: 08/04/16  
~~D333~~ QA: N/C Closed: D Date: 08/04/16

NCR: 37079		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/25	3.0	1 parts The slot of .625 IS too big. .645.  P.C. operator error X origin was off on second operation.	<i>[Signature]</i>	<del>Part not replace</del> Scrap & replace QTY 1 M. 107220	DSD 08/04/26	<i>[Signature]</i> Aug 26	<i>[Signature]</i> Korian	<i>[Signature]</i> 08/04/26

NOTE: Date &amp; initial all entries

Date: Wednesday, 1/30/2008 7:56:57 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT PIN BRACKET

Job Number: 37079

Part Number: D333013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mf 08/02/26 16*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA15*

*PA 08.04.14 (X10)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/15*

Job Completion



*mf 08-04-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37079
<b>Description:</b> Short Pin Bracket		<b>Part Number:</b>	D3330-13
<b>Inspection Dwg:</b> D3330	<b>Rev:</b> <i>ED</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.030	2.995	✓			
2.625	+/-0.010	2.635	✓			
0.260	+/-0.010	.258	✓			
Ø0.594	+0.005/-0.000	.596	✓			
0.625	+/-0.010	.628	✓			
0.500	+/-0.010	.505	✓			
2.25	+/-0.030	2.255	✓			
Ø0.531	+0.005/-0.000	.531	✓			
0.950	+/-0.010	.949	✓			
Ø0.348	+0.005/-0.000	.349	✓			
Ø0.467	+/-0.010	.470	✓			
1.250	+/-0.010	1.251	✓			
1.00	+/-0.030	1.00	✓			
0.10 x 45°	+/-0.030	.108	✓			
Ø0.516	+0.005/-0.000	.520	✓			

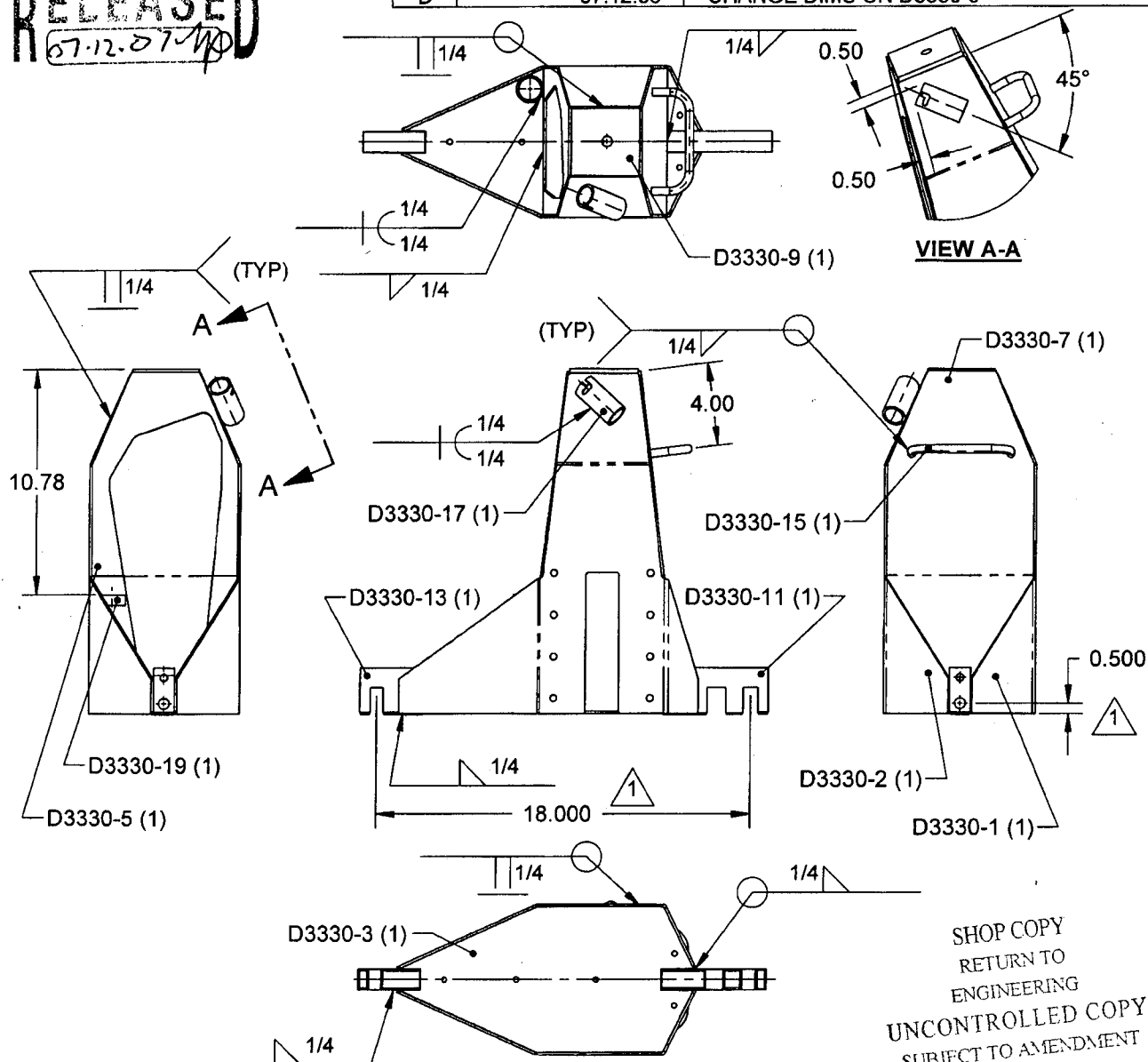
<b>Measured by:</b> <i>S.F.</i>	<b>Audited by:</b> <i>aml</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/02/25	<b>Date:</b> 08/02/26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC <i>JA</i>	<i>BE</i>

*JA*

**DART****RELEASED**  
07-12-07

DESIGN <i>13</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>13</i>	APPROVED <i>WFP</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>	TITLE <b>FRAME WELDMENT</b>	SCALE 1:8	
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. **37079**

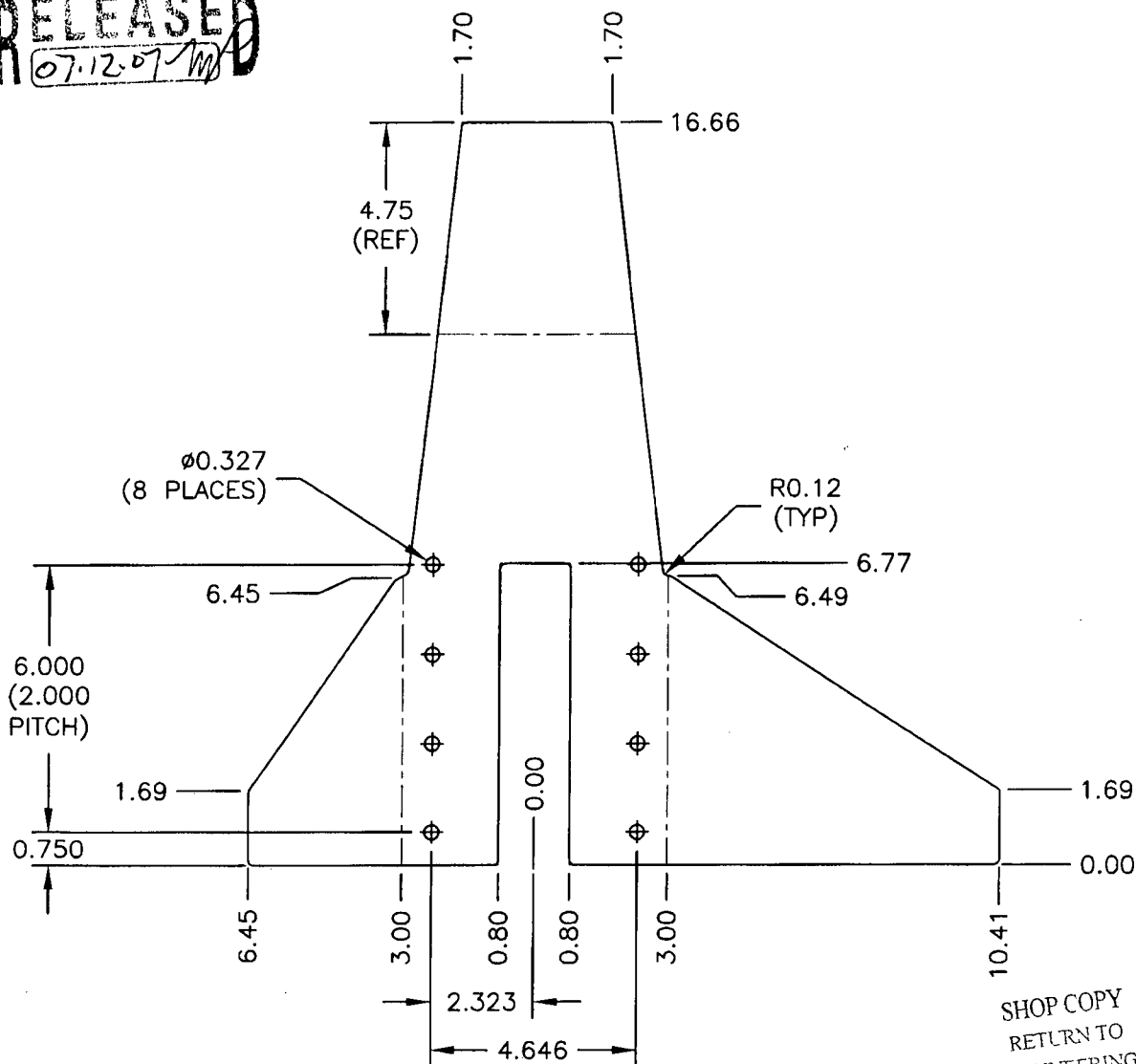
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07.12.07 *[Signature]*



### D3330-1 PANEL

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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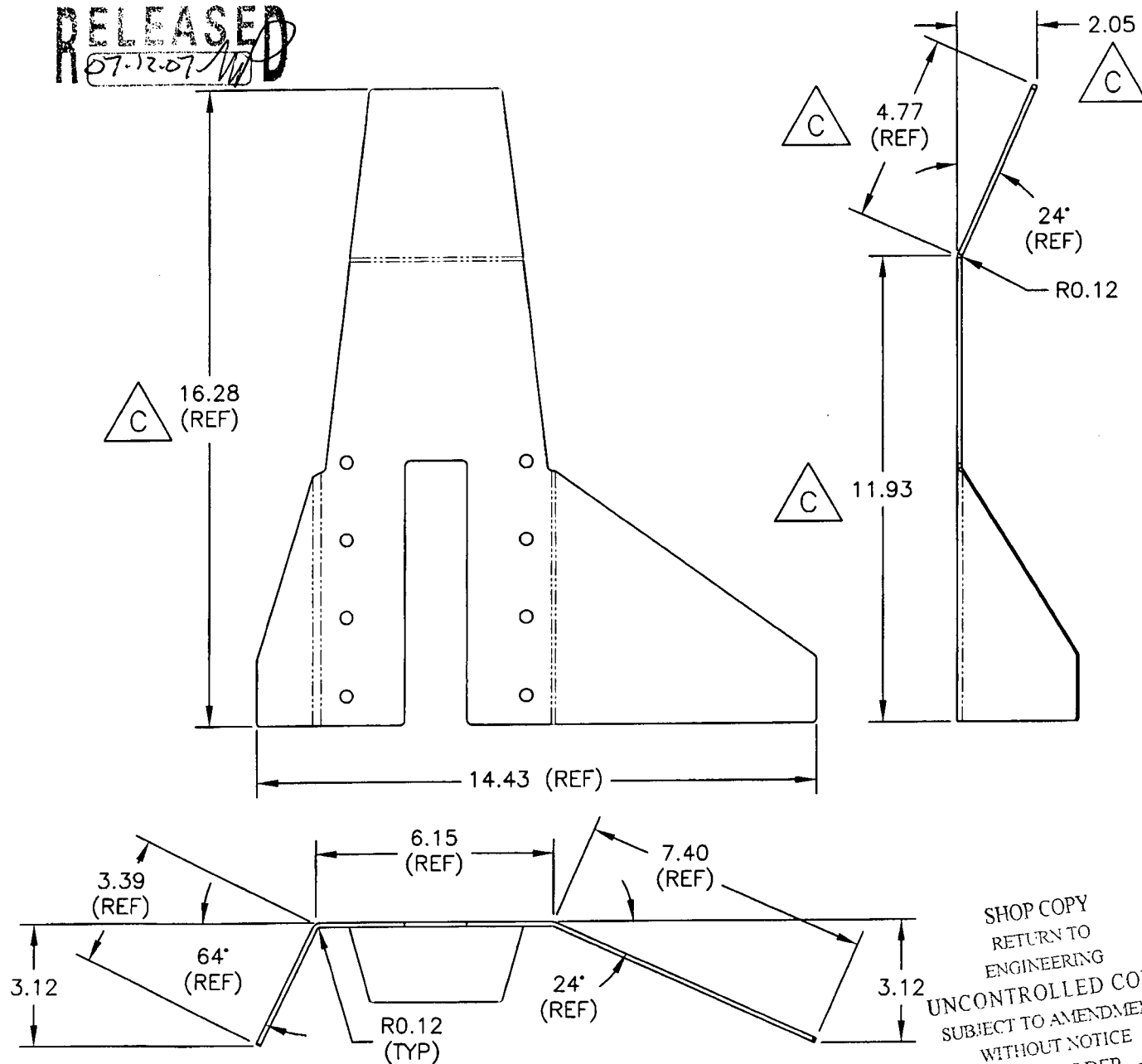
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

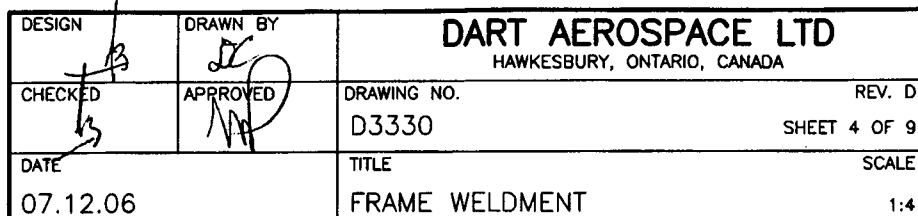
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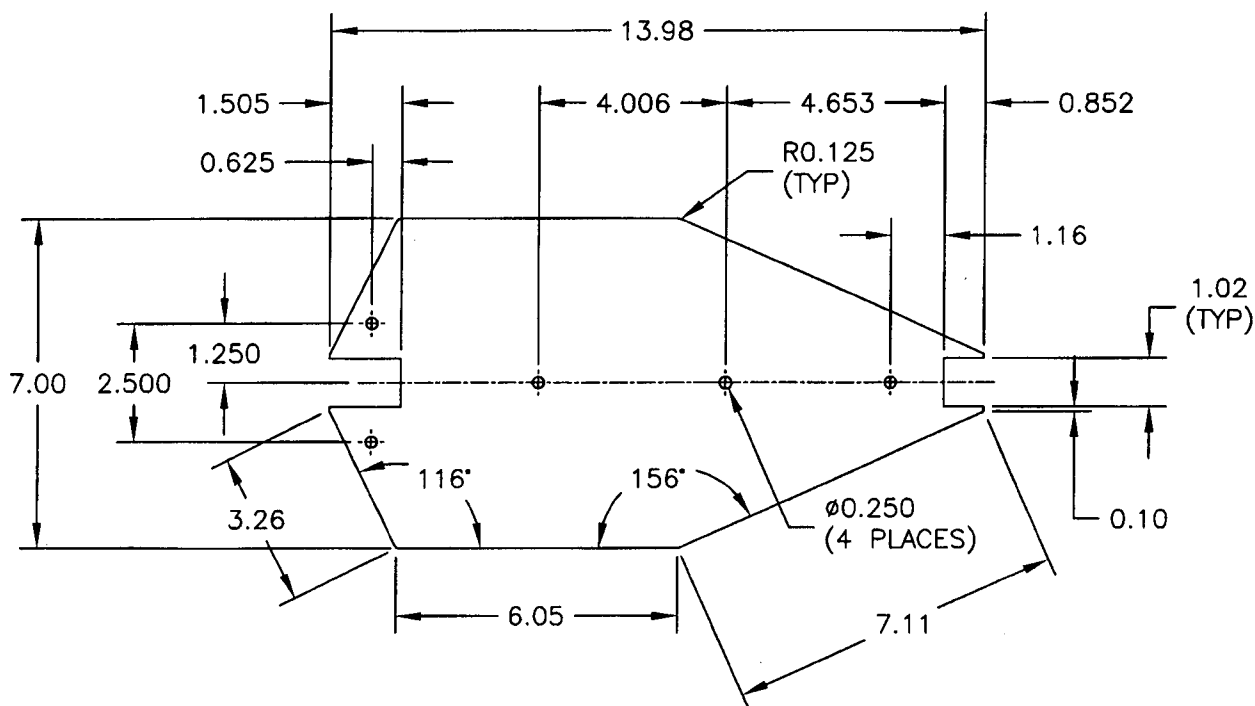
**D3330-1 BEND DETAIL (SHOWN)**  
BEND D3330-2 (OPPOSITE)

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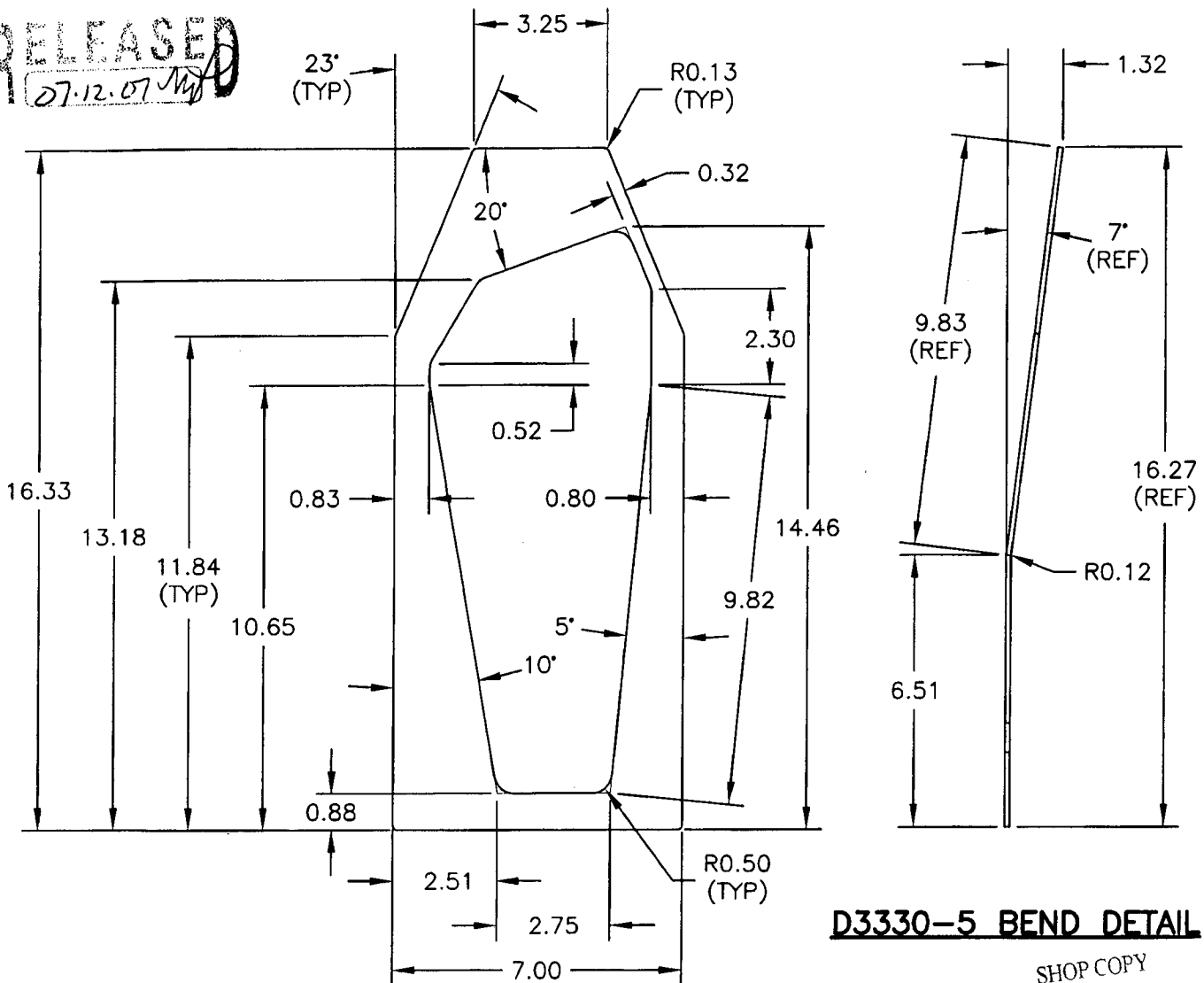
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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**FLAT PATTERN****D3330-5 BEND DETAIL**

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**NOTES:**

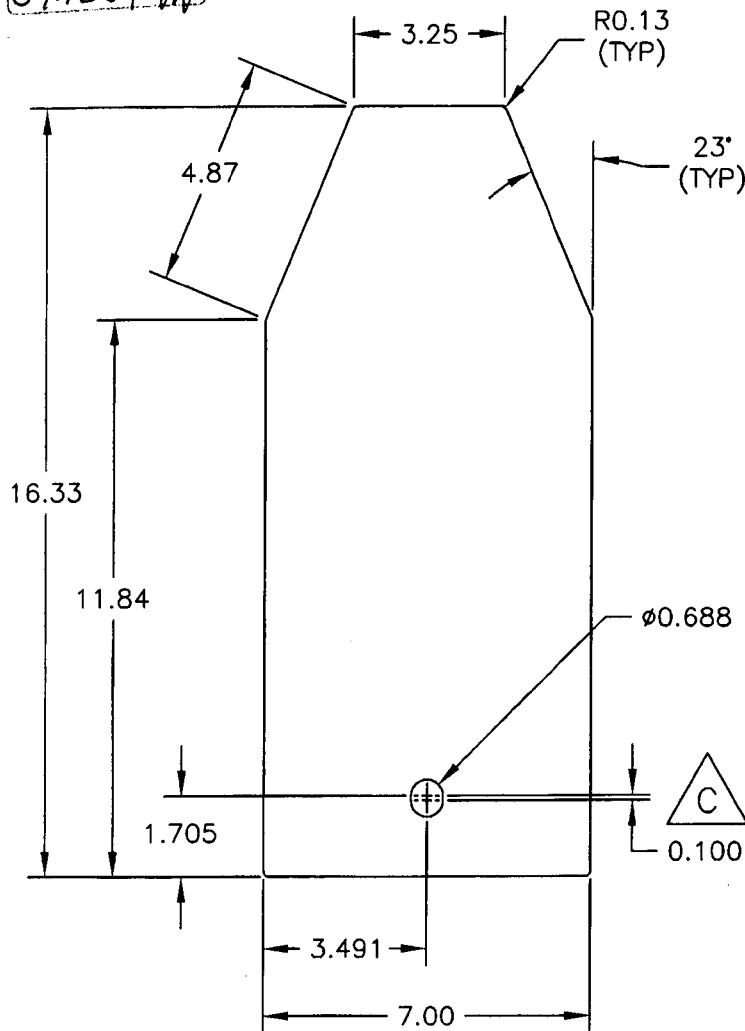
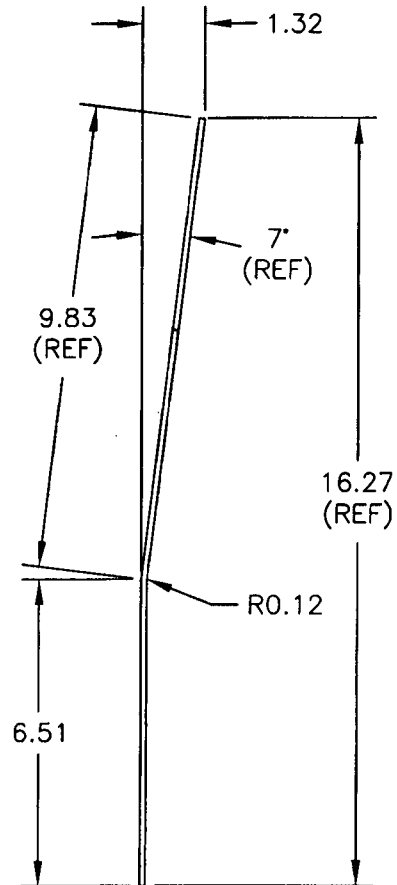
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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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07.12.07 *[Signature]***FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

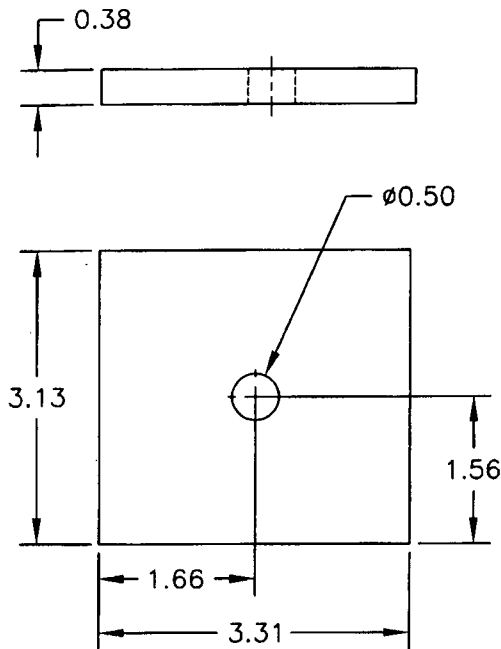
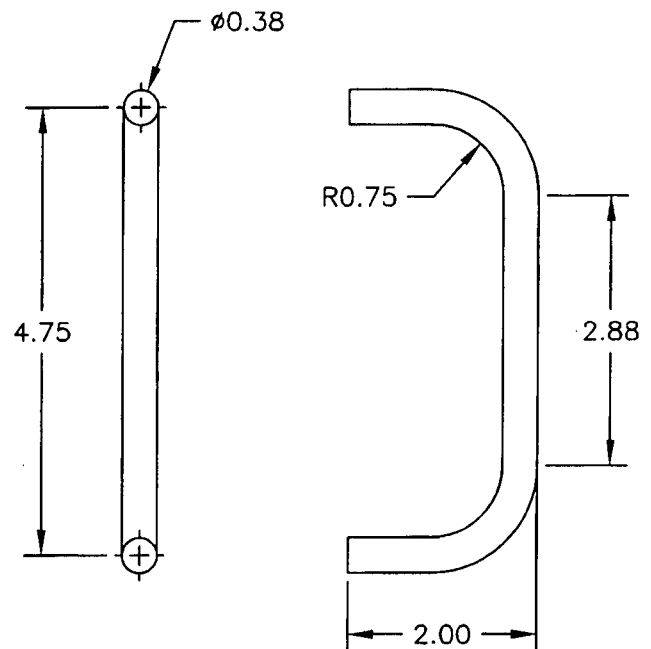
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED  
07.12.07**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

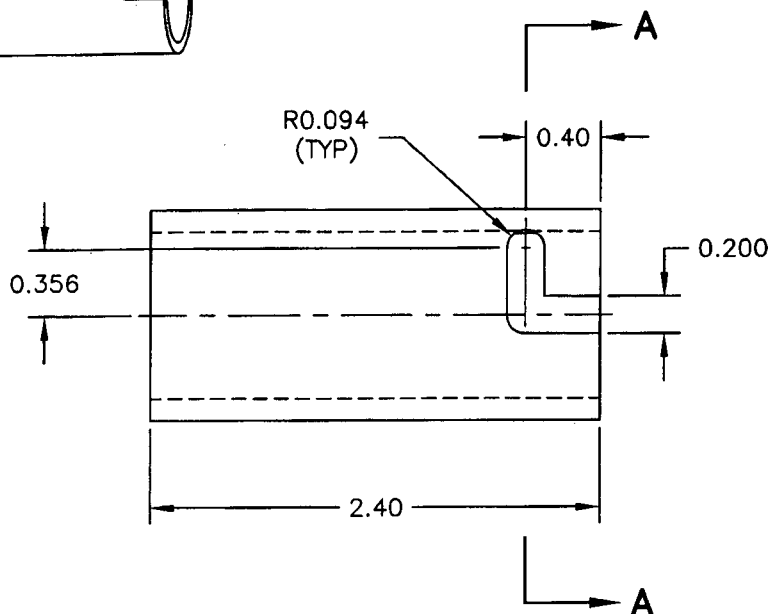
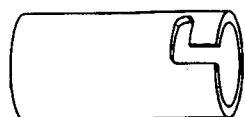
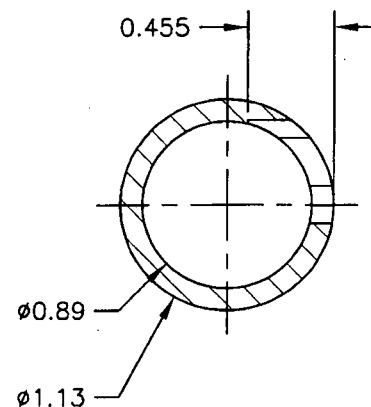
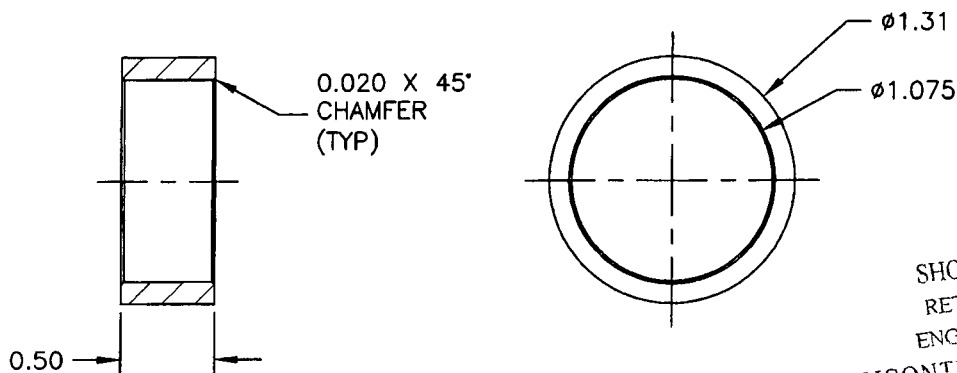
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

**RELEASED**  
07.12.07 *MP***SECTION A-A****D3330-17 HANDLE SOCKET****D3330-19 HANDLE RIM****NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097  
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

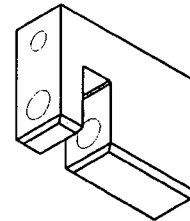
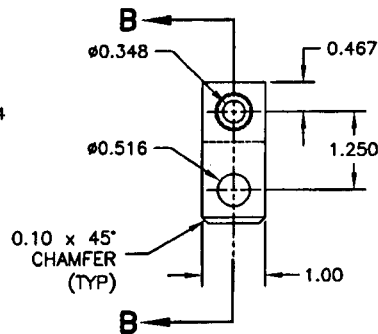
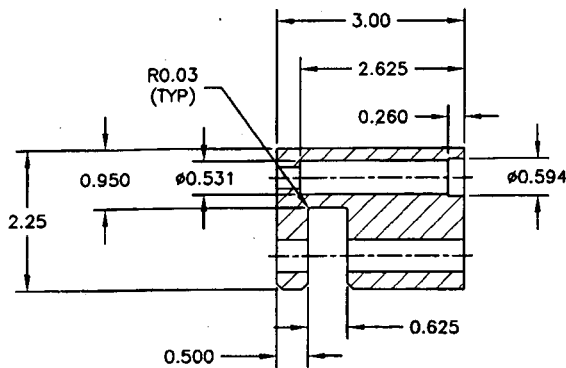
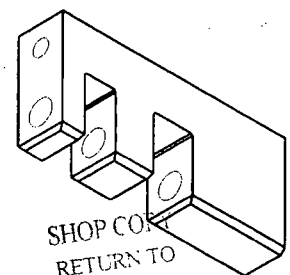
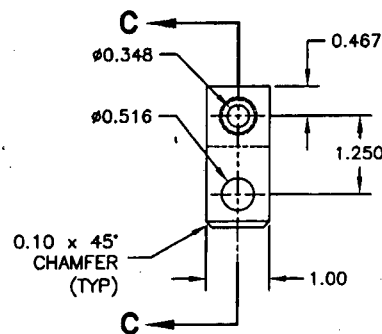
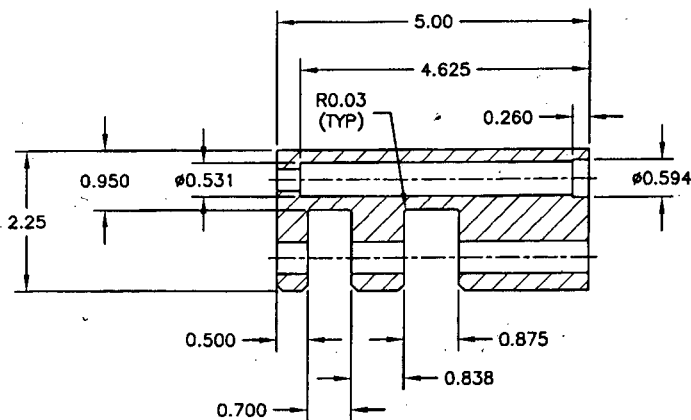
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**RELEASED**  
07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET**

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**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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